

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.9/14.3,0.0/1.6File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000851**Date Inspected:** 11-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower Mock Up**Summary of Items Observed:**

Orthotropic Box Girder (OBG):

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the OBG.

The QA Inspector randomly observed ZPMC tack welder Liu Zihong ID Number 062447, utilizing the Flux Cored Arc Welding (FCAW) Process with ZPMC approved Weld Procedure Specification (WPS)

WPS-B-T-2231-U2-F-1, to tack weld various lengths of W21 X 57 I-Beams prior to welding butt splices. The following photograph provides additional detail.

OBG BOTTOM/SIDE PLATES:

The QA Inspector was asked by the Day Shift Caltrans Lead Inspector on the Day Shift, Alfredo Acuna, to try to verify that new FCAW Welding Wire was used to tack weld the sections of Bottom Plate Mark 36B, Bottom Plate Mark 37B and Side Plate Mark 63B, which were tack welded on 11/10/07 by ZPMC Tack Welder He Yu Mei ID Number 048625. The QA Inspector was assisted by ZPMC QA Representative Eric Xu, and was able to review the ZPMC Welding Wire Tracking Log (WWTL) for 11/10/07. The QA Inspector was unable to obtain a copy of the WWTL for 11/10/07 because of protocol, but was able to photograph it. The QA Inspector was not able to fully verify all of the information on the WWTL. That information will have to be translated after a copy of the WWTL is forwarded to Caltrans on Monday 11/12/07. The following photograph provides additional detail.

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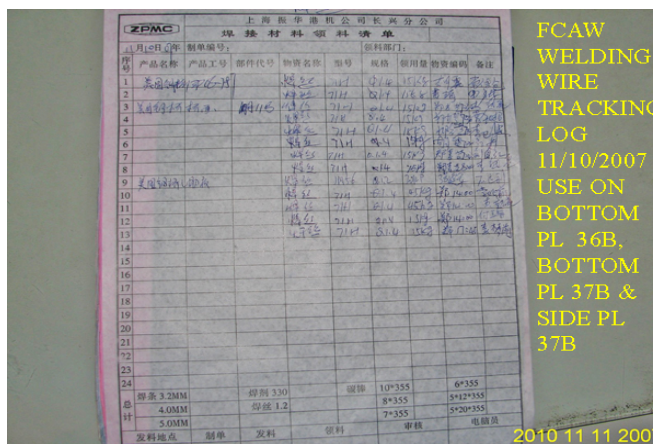
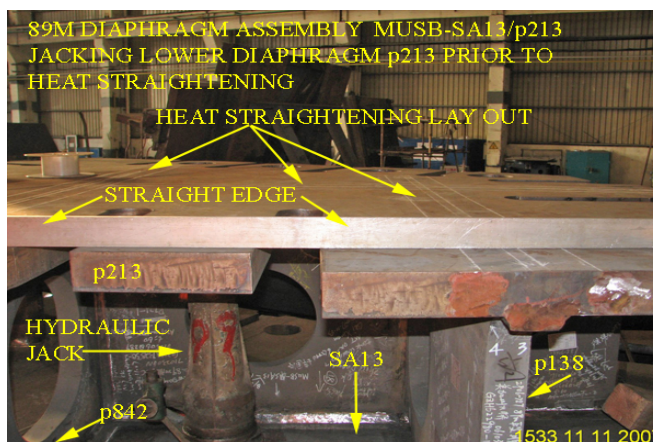
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Tower Mock Up:

Elevation 89M:

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the fabrication of the Tower Mock Up.

The QA Inspector randomly observed ZPMC welding personnel utilizing hydraulic jacks to remove the camber in 89M Lower Diaphragm MUSA-p213 of 89M Diaphragm Assembly MUSA-SA13/p213, prior to performing heat straightening operations. The following photograph provides additional detail.



Summary of Conversations:

The QA Inspector asked ZPMC QA Representative Eric Shue to provide Bureau Veritas Representative Arbin, with a copy of the WWTL for 11/10/07. The QA Inspector then asked Bureau Veritas Arbin, if he would forward the copy of the ZPMC WWTL to American Bridge/Fluor Enterprises, a JV (ABF), and that Arbin request that a copy of the ZPMC WWTL be then forwarded to Caltrans for their review. The QA Inspector observed Mr. Xu give a copy of the ZPMC WWTL to Arbin, and Arbin informed the QA Inspector that he would forward it to ABF for distribution to Caltrans.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Franco,Charlie	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
